Work Order ID 62023

Wednesday, September 15, 2010 10:02:28 A

Item ID: D3531-041 **Accept**

Revision ID:

Item Name: Bracket Assembly

Setup **Start** **Stop**

Start Date: 9/14/2010 **Start Qty:** ~~4.00~~ 5

Required Date: 9/21/2010 **Req'd Qty:** 4.00

Cust Item ID:

Customer:

Reference:

Approvals: **Process Plan:** [signature] **Date:** 10-9-15 **Tooling:** _____ **Date:** _____

QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Run **Start** **Stop**

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp

Draw Nbr	Revision Nbr
D3531	Rev A

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
100 Small Fab Small Fab	Small Fab **Memo** Assemble as per dwg D3531	0.00 0.00				[signature] 10/09/27			5
110 QC Quality Control	QC5- Inspect part completeness to step on W/O **Memo**	0.00 0.00	[signature] 10/09/27			x5			
120 Powdercoat Powder Coating	Black Sandtex(Ref:4.3.5.7) per QSI005 4.3 M112588 **Memo** START TIME: 10:35 ☐OVEN TEMPERATURE: 320° ☐FINISH TIME: 11:05	0.00 0.00	[signature] 10-9-29			5	∅		

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W/O:		WORK ORDER CHANGES					
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	**STEP**	**Description of NC** Section A	**Corrective Action** Section B			**Verification** Section C	**Approval** Chief Eng	**Approval** QC Inspector
			Initial Chief Eng	**Action Description** Chief Eng	**Sign & Date**			

NOTE: Date & initial all entries

Work Order ID 62023

Wednesday, September 15, 2010 10:02:28 A

Item ID: D3531-041 **Accept** **Setup** **Start** **Stop**

Revision ID:

Item Name: Bracket Assembly

Start Date: 9/14/2010 **Start Qty:** 4.00 **Cust Item ID:**

Required Date: 9/21/2010 **Req'd Qty:** 4.00 **Customer:**

Reference:

Run **Start** **Stop**

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 QC Quality Control	QC3- Inspect Part Finish	0.00	=> MJ 10/09/29			x5	Ø		
	Memo	0.00							
140 Packaging Packaging	Identify as per dwg & Stock Location: 181	0.00				10/9/29			
	Memo	0.00							
150 QC Quality Control	QC21- Final Inspection - Work Order Release	0.00						10/09/30	
	Memo	0.00							

MF 10-9-29

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W/O:		WORK ORDER CHANGES					
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Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

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			Initial Chief Eng	**Action Description** Chief Eng	**Sign & Date**			

NOTE: Date & initial all entries

Picklist Print

Wednesday, September 15, 2010 10:02:32 AM

Work Order ID: 62023

Parent Item: D3531-041

Parent Item Name: Bracket Assembly

Start Date: 9/14/2010 **Required Date:** 9/21/2010

Start Qty: 4.00 **Required Qty:** 4.00

Comments: IPP Rev:A New Issue 07-09-24 EC verified DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3531-1 Bracket		Manufactured	No			100	Each	8.0000	1	4			
				Location		**Loc Qty**		**Loc Code**					
				st238		8							
					53912	8				5	SN	10/09/24	
D3531-3 Bracket Front Plate		Manufactured	No			100	Each	3.0000	1	4			
				Location		**Loc Qty**		**Loc Code**					
				ST068	B 6(78)	3				(5)	SN	10/09/24	
					50214	~~3~~							
MS20470AD4-4 Rivet, Universal Head		Purchased	No			100	Each	3,758.000	12	48			
				Location		**Loc Qty**		**Loc Code**					
				ST319		3758							
					112314	30							
					113368	92							
					115470	3636				56	SN	10/09/24	

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W/O:		WORK ORDER CHANGES					
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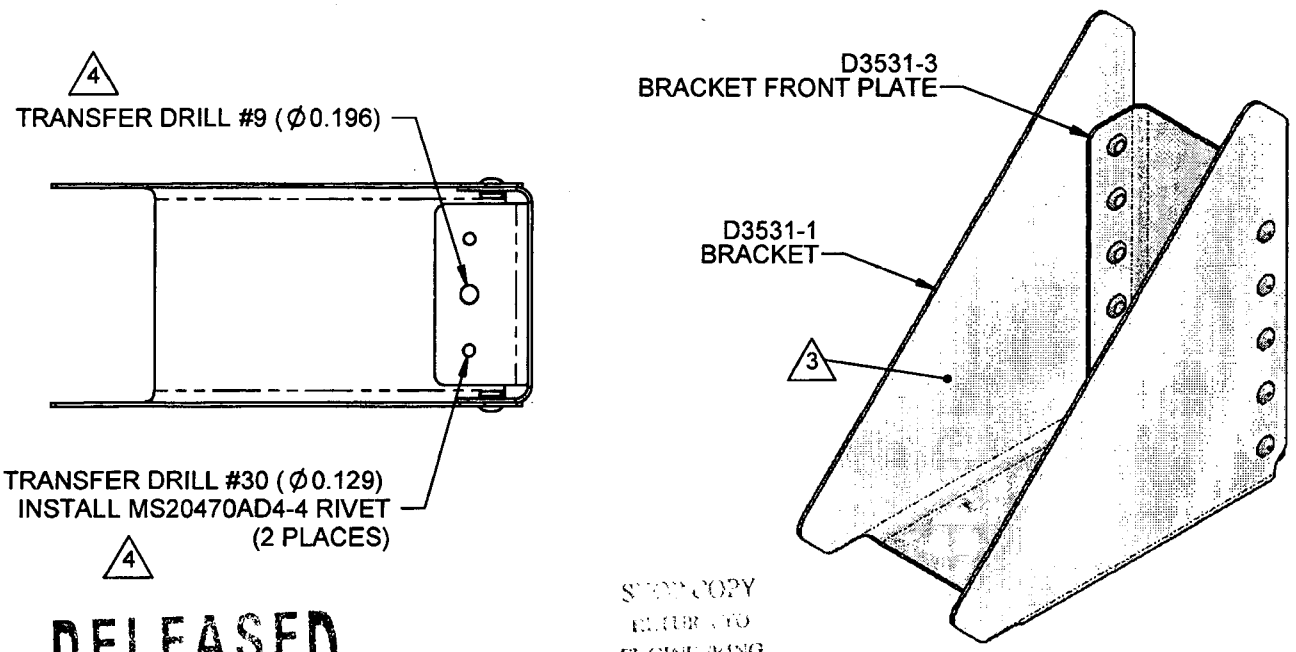
			Initial Chief Eng	**Action Description** Chief Eng	**Sign & Date**			

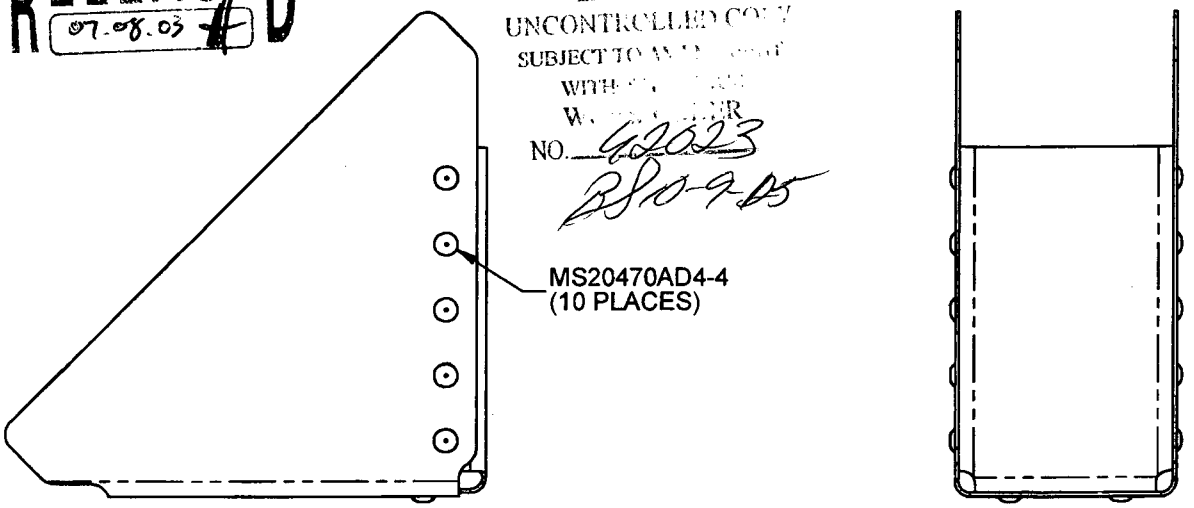
NOTE: Date & initial all entries

DESIGN	DRAWN BY	DART AEROSPACE LTD
CB	CB	HAWKESBURY, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO. / REV.
LE		D3531 REV. A
DATE		TITLE / SCALE
07.06.19		BRACKET ASSEMBLY 1:2

REV	DATE	DESCRIPTION
A	07.06.19	NEW ISSUE



RELEASED
07.08.03



D3531-041 BRACKET ASSEMBLY

NOTES:
1) FINISH: POWDER COAT ASSEMBLY BLACK SANDTEX (4.3.5.7) PER DART QSI 005 4.3 ALL PARTS
2) ASSEMBLE PER DART QSI 003
3) IDENTIFY WITH DART P/N "D3531-041" USING WHITE MARKER ON INSIDE OF BRACKET ASSEMBLY, WHERE INDICATED
4) TRANSFER DRILL HOLES FROM D3531-1 BRACKET THROUGH D3531-3 BRACKET FRONT PLATE BEFORE FINISHING

PARTS LIST

QTY.	P/N	DESCRIPTION
X	D3531-041	BRACKET ASSEMBLY
1	D3531-1	BRACKET
1	D3531-3	BRACKET FRONT PLATE
12	MS20470AD4-4	RIVET

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W/O:		WORK ORDER CHANGES					
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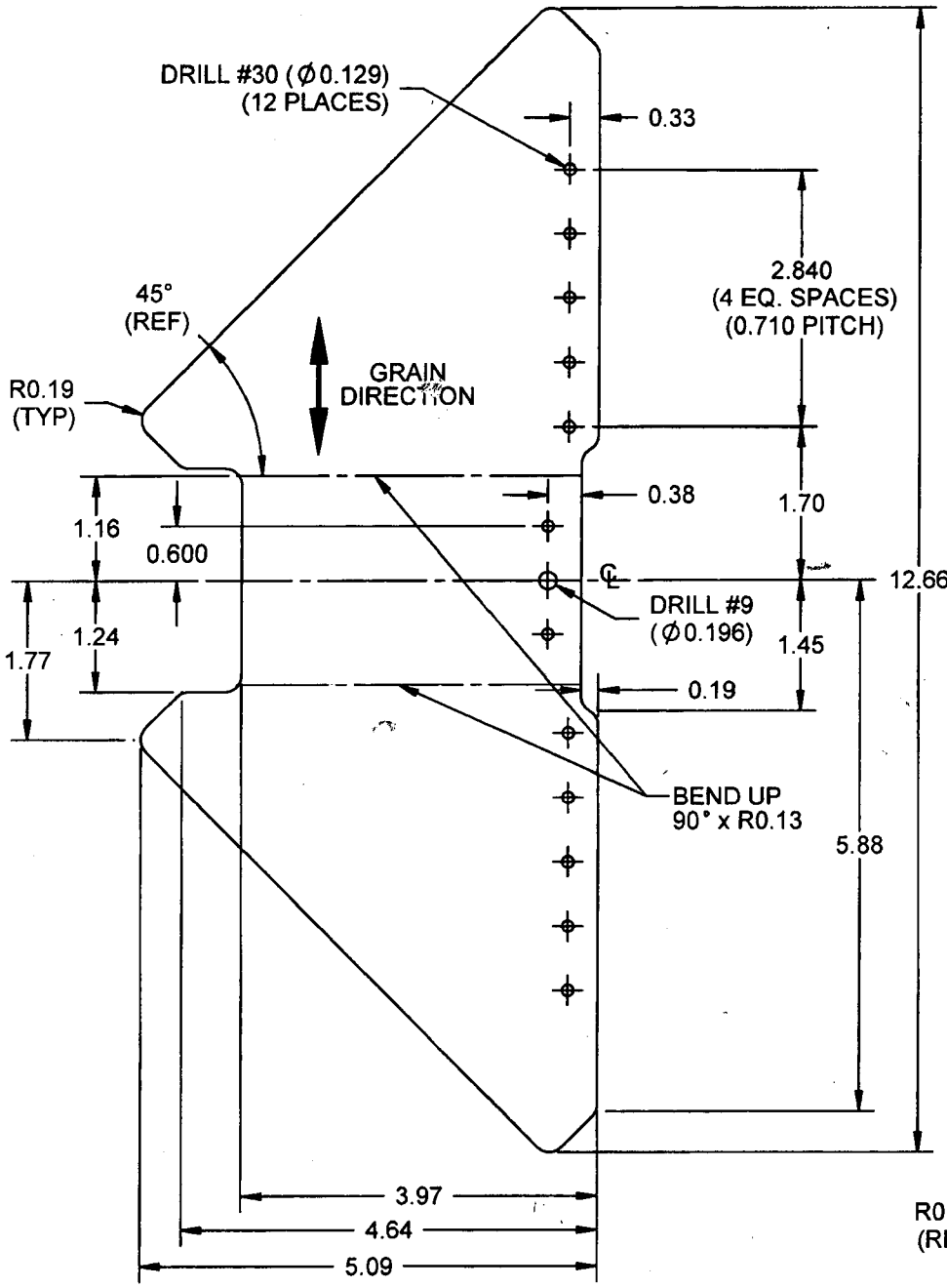
			Initial Chief Eng	**Action Description** Chief Eng	**Sign & Date**			

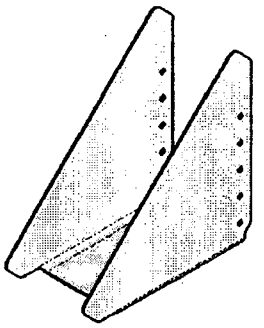
NOTE: Date & initial all entries

DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CB	CB		
CHECKED	APPROVED	DRAWING NO.	REV. A
CE		D3531	SHEET 2 OF 3
DATE		TITLE	SCALE
07.06.19		BRACKET ASSEMBLY	1:2

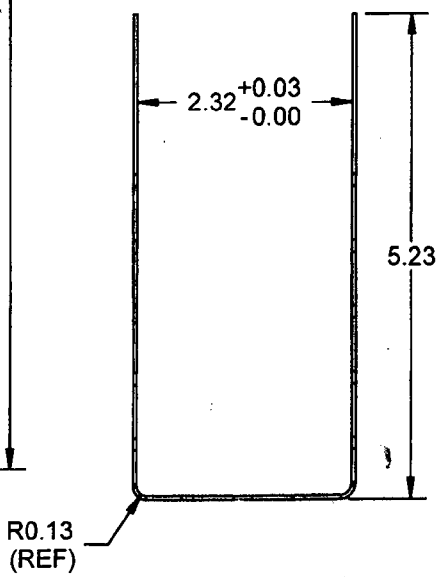
w/o 62023



D3531-1F FLAT PATTERN



RELEASED
07.08.03



D3531-1 BRACKET

NOTES:
1) MATERIAL: ALUMINUM 6061-T6/T62 SHEET, 0.040 THICK PER QQ-A-250/11 OR AMS 4025 OR AMS 4027 (REF DART SPEC M6061T6S.040)
2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
5) BREAK ALL SHARP CORNERS TO 0.010 MAX
6) PART IS SYMMETRIC ABOUT ℄

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			Initial Chief Eng	**Action Description** Chief Eng	**Sign & Date**			

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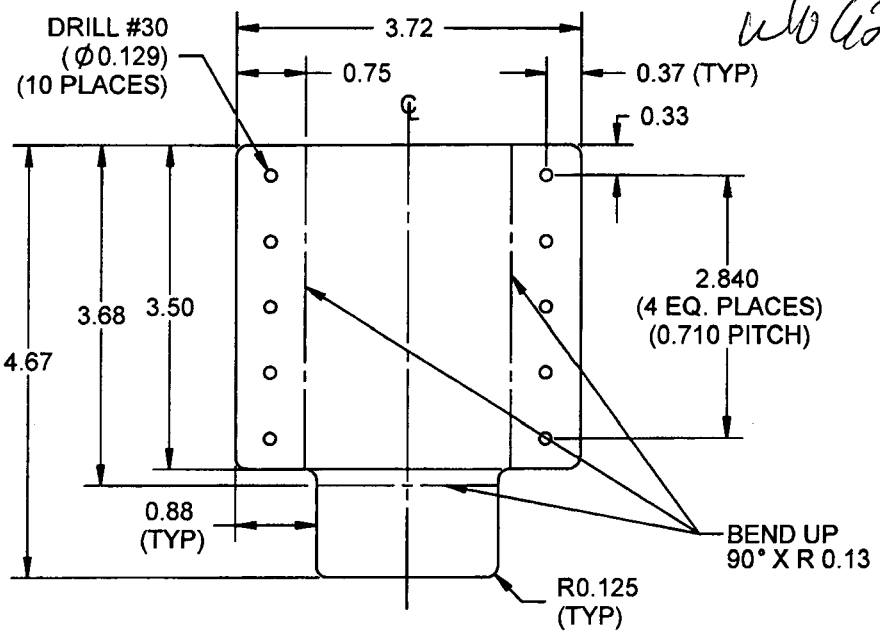
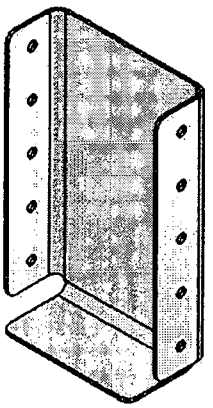
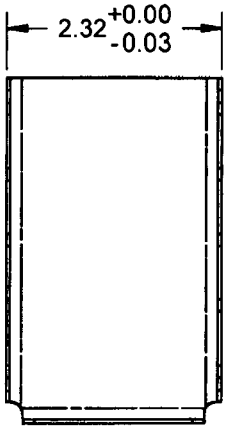
CB	CB		
CHECKED	APPROVED	DRAWING NO.	REV. A
LE		D3531	SHEET 3 OF 3
DATE		TITLE	SCALE
07.06.19		BRACKET ASSEMBLY	1:2

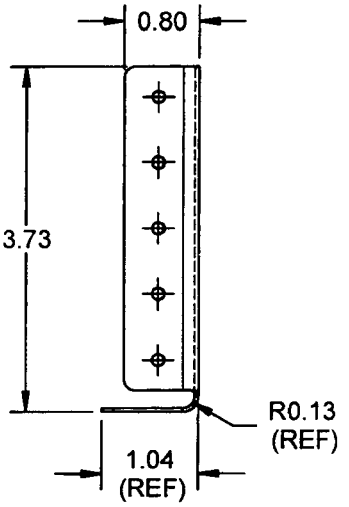
WO 42062 RELEASED 07.08.03





D3531-3F FLAT PATTERN





D3531-3 BRACKET FRONT PLATE

NOTES:
1) MATERIAL: ALUMINUM 6061-T6/T62 SHEET, 0.040 THICK PER QQ-A-250/11 OR AMS 4025 OR AMS 4027 (REF DART SPEC M6061T6S.040)
2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
5) BREAK ALL SHARP CORNERS TO 0.010 MAX
6) PART IS SYMMETRIC ABOUT ℄

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